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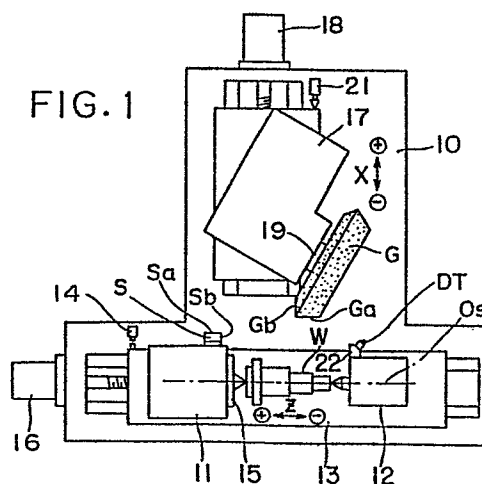
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(54) **Numerical control grinding machine.**

(57) In a numerical control grinding machine, movements of a wheel head and a work table respectively in first and second directions perpendicular to each other are controlled by reference to first and second present position registers which respectively represent positions of cylindrical and shoulder grinding surfaces of a grinding wheel rotatably carried on the work head. A reference member is secured to the work table, and a wheel head reference point is defined on the wheel head. A memory device stores data which represents positions in the first and second directions, of the wheel head reference point relative to a workpiece rotational axis and the reference member when the wheel head and the work table are at respective original positions. The memory device further stores data which represents positions in the first and second directions, of the cylindrical and shoulder grinding surfaces relative to the wheel head reference point. When given a command after the present position registers lose their contents due to power failure or emergency stop, a central processing unit of a numerical controller for the machine calculates the present positions of the cylindrical and shoulder grinding surfaces based upon the stored data in the memory device and sets the present position registers respectively with the calculated present positions.





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EUROPEAN SEARCH REPORT

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EP 85 10 5951

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 4)
X	JP-A-58 132 460 (TOYODA KOKI K.K.) * Page 418(2), right-hand column, paragraph 4, from "figure 1" - page 421(5), paragraph 3, last line; figures 1-4 *	1	G 05 B 19/18 B 24 B 5/01
A	DE-A-3 316 321 (TOKYO SHIBAURA DENKI) * Abstract; claims 1-16; figure 2 *	2-5	
A	EP-A-0 081 217 (OERLIKON-BOEHRINGER GmbH) * Whole document *	1-3	
A	PATENT ABSTRACTS OF JAPAN, vol. 7, no. 173 (M-232)[1318], 30th July 1983; & JP-A-58 77 450 (TOYODA KOKI K.K.) 10-05-1983	3-5	TECHNICAL FIELDS SEARCHED (Int. Cl. 4) G 05 B 19 B 24 B 5
E	US-A-4 502 125 (TOYODA KOKI K.K.) * Column 4, line 42 - column 9, line 43; figures 1-4 *	1	
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 28-07-1987	Examiner KLOS
<p>CATEGORY OF CITED DOCUMENTS</p> <p>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</p> <p>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document</p>			